



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D044-662-041
Job Sheet 178766



003805

Part No: D044-662-041

Job Qty: 1 ea

Part Name: R44 Bearpaw Wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 6/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A New Issue 07-01-30 JLM IPP Rev:B As per Ecn 932 & 862 07-03-28 JLM

Ship Via:

10
9-99 Chg 001
21 See attachment
9-99

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/20/18	6/20/18	0.00	0.00	Start Up Stores/Pkg-1		JUN 11 2018
110	Packaging	1 pcs	6/20/18	6/20/18	0.00	0.00	Packaging1-1		JUN 11 2018
120	QC	1 pcs	6/20/18	6/20/18	0.00	0.00	QC4		
130	Packaging	1 pcs	6/20/18	6/20/18	0.00	0.00	Packaging3-1		
135	DC	1 pcs	6/20/18	6/20/18	0.00	0.00	DC		
140	QC21-FG	1 Ea	6/20/18	6/20/18	0.00	0.00	QC21		

Fg128

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-12A	Bolt	4 Ea (4 ea)	90-Start up Operation	5048377
AN4-16A	Bolt	4 Ea (4 ea)	90-Start up Operation	5068654
D2274	Radius Block	4 Ea (4 ea)	90-Start up Operation	5067935
D2529	Washer	4 Ea (4 ea)	90-Start up Operation	5035698
D3565-1	Wearplate	4 Ea (4 ea)	90-Start up Operation	5071329
MS21042L4	Nut	4 Ea (4 ea)	90-Start up Operation	5056039

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-12A	4	74	0
	AN4-16A	4	331	0
	D2274	4	275	0
	D2529	4	1,897	0
	D3565-1	4	10	0
	MS21042L4	4	3,141	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Step _____	DISPOSITION Rework ☐	AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Engineering Quality Other ☐																																																										
Description Work Order _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																										
 Container No: S079969 Part: D044 - 662 - 041 Job No: 178766 Serial No/Batch: S079969 Revision: Inspector: Exp Date: Instructions:		Date: 06/11/18																																																										
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width: 15%;">Environment</td> <td style="width: 15%;">☐</td> <td style="width: 15%;">No Re-verification</td> <td style="width: 15%;">☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> </tr> <tr> <td colspan="4" style="text-align: center;">OTHER : _____</td> </tr> </tbody> </table>					Root Cause				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	OTHER : _____			
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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-662-011 Bearpaw Installation	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.1 in 3.25 m	589 in-lb 6.8 m-kg
D044-662-013 Bearpaw Installation	6.2 lb 2.81 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	129.1 in 3.28 m	800 in-lb 9.2 m-kg
D044-662-041 Wearplate Kit (installed on D044-662-011/-013 Bearpaw Kit)*	1.6 lb 0.73 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.3 in 3.26 m	205 in-lb 2.4 m-kg

*D044-662-041 weight and balance should be added to D044-662-011/-013 kits

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
4	4		D4953-1	Cushion (Replaces D2182B045 Cushion)
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		NAS1149D0463J	Washer (Replaces AN960JD416 Washer)
8	8	4	MS21042L4	Nut (or MS21042-4)

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Revision: E
Date: 15.03.20

Change Record

PAGE 1 OF 1

Part Number: D044-662-041

Description: WEARPLATE INSTALLATION

[illegible]